

Date: Friday, 7/20/2007 10:19:47 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: NUT PLATE ASSEMBLY
Job Number	: 33692		
Estimate Number	: 11054		
P.O. Number	:	Part Number	: D2873045
This Issue	: 7/20/2007 S.O. No. :	Drawing Number	: D2873 REVA
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 32777	Material	:
Written By	:	Due Date	: 8/10/2007 Qty: 30 Um: Each
Checked & Approved By	: <u>07.07.20</u>		
Comment	: Est A 05.09.13 New issue KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0375X01000	6061T6 BAR
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Comment: Qty.: 0.2363 f(s)/Unit Total : 7.0875 f(s)  
 6061T6 BAR  
 Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-225/8)  
 (M6061T6B0.375x01.000)  
 Identify for D2873-5  
 Batch: 1105445

07.09.28 (30)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
 Cut blanks: 1.000" x 0.375" x 2.700" long

07.09.28 (50)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine as per Folio FA and Dwg D2873  
 Identify as D2873-5 Dwg Rev A Folio Rev AA

07.09.30 (30)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07.09.30 (30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 33692

Part Number: D2873045

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

31 07/09/30

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Debur

2- C'sink as per Dwg D2873

SAD

07-10-02

counted

30

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counter 07/10/02 30

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BL 07-10-02

30

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION

counter 07/10/02 30

10.0

MS20426AD46

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 120.0000 Each(s)

Rivet

Pick;

Qty

Part Number

Description

Batch

4

MS20426AD4-6

Rivet

M103395

CU

11.0

MS21075L5

Nut Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 60.0000 Each(s)

Nut Plate

Pick;

Qty

Part Number

Description

Batch

2

MS21075L5

Nut Plate

M18136

CU

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 7/20/2007 10:19:47 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 33692

Part Number: D2873045

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2873

2-Identify as D2873-045

SAD 07-10-02

(30)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EW 07/10/03 (30) counts

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LAN

EW 07/10/03 (30)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.10.03

Job Completion



EW 07.10.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	33692
<b>Description:</b> Radius Block		<b>Part Number:</b>	D2873-5
<b>Inspection Dwg:</b> D2873 <b>Rev:</b> A		<b>Page 1 of 1</b>	

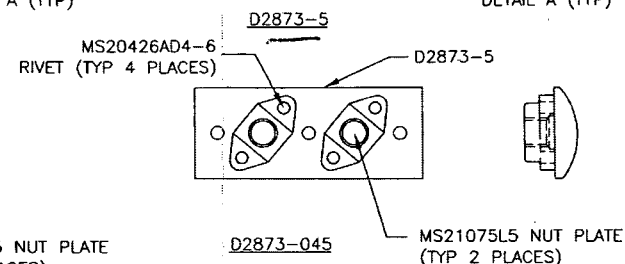
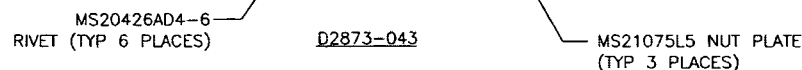
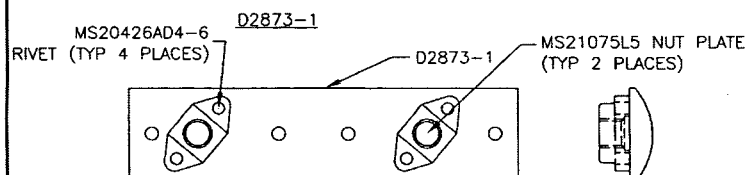
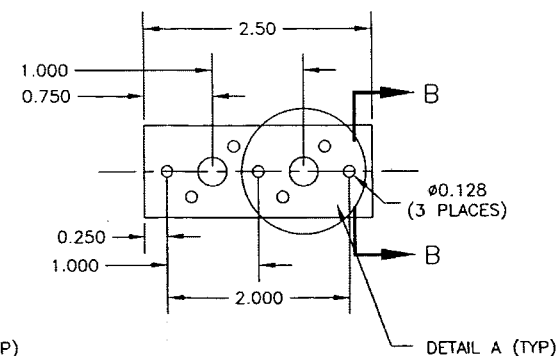
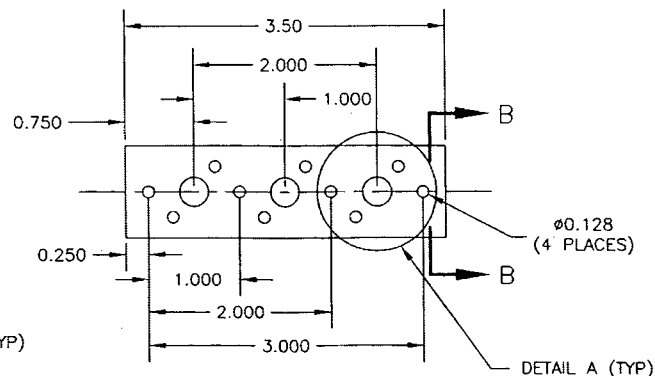
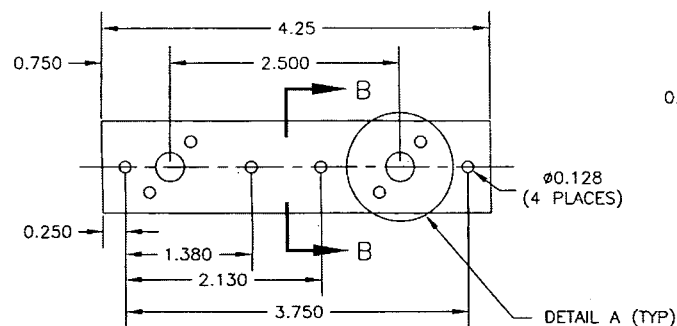
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.030	2.500	✓			
1.000	+/-0.010	1.000	✓			
0.750	+/-0.010	.750	✓			
0.250	+/-0.010	.250	✓			
1.000	+/-0.010	1.000	✓			
2.000	+/-0.010	2.000	✓			
Ø0.128	+0.005/-0.001	.130	✓			
0.359	+/-0.010	.360	✓			
Ø0.316	+0.006/-0.001	.318	✓			
1.000	+/-0.010	1.000	✓			
0.250	+/-0.010	.250	✓			
0.061	+/-0.010	.061	✓			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	.229 x .125	✓			

<b>Measured by:</b> <i>SG</i>	<b>Audited by:</b> <i>JML</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07.09.29	<b>Date:</b> 07/09/29	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue      P/O D2873-045	KJ/JLM <i>KA</i>	<i>SG</i>



#### D2873-1/-3/-5 RADIUS BLOCK

- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X0.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100'

#### D2873-041/-043/-045 NUT PLATE ASSEMBLY

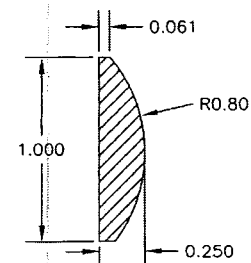
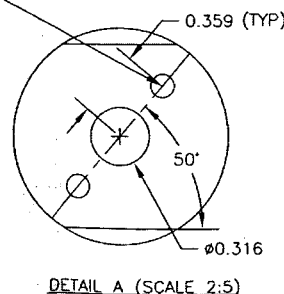
- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

#### D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE

(-041 4 PLACES)  
(-043 6 PLACES)  
(-045 4 PLACES)

NO. 33642  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY



SECTION B-B (SCALE 2:5)

A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	<b>DART</b> DART AEROSPACE LTD WILLOWDALE, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D2873
DATE 05.07.26		TITLE RADIUS BLOCK
		REV. A SHEET 1 OF 1 SCALE 4:5

RELEASED  
05-07-26-06